



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON PER MIL-T-21014D, CLASS 3, UHV GRADE
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS .001
9. DIMENSIONS IN () ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS $\sqrt{63}$

REF. SOURCE

KULITE TUNGSTEN CORP.
160 EAST UNION AVENUE
EAST RUTHERFORD, NJ 07073 OR
TEL: 1-201-438-9000
FAX: 1-201-438-0891

MITEK METALS INC.
1340 NORTH SENATE AVENUE
INDIANAPOLIS, IN 46202
TEL: 1-317-637-3574
FAX: 1-633-7224

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<p>UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES</p> <p>TOLERANCES</p> <p>DECIMALS ANGULAR</p> <p>IN .1 (2.5) .010</p> <p>IN .01 (0.25) .001</p> <p>IN .005 (0.127) .0005</p> <p>SURFACE ROUGHNESS $\sqrt{63}$</p> <p>REMOVE ALL BURRS AND BREAK SHARP EDGES .02 MAX.</p> <p>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASST DASH</p> <p>REVISIONS & TOLERANCES IN ACCORDANCE WITH LATEST ASST TOL</p>				
<p>PARTS LIST</p> <p>S3220002-01</p> <p>ARGONNE NATIONAL LABORATORY</p> <p>THIS DRAWING IS THE PROPERTY OF</p> <p>ADVANCED PHOTON SOURCE</p> <p>S3 I.D. SAFETY SHUTTER</p> <p>TUNGSTEN BLOCK</p> <p>RIGHT & LEFT LOWER SHUTTER</p>				
<p>DRAWN BY</p> <p>MUSCIA</p>		<p>DATE</p> <p>5/11/98</p>	<p>CHIEF DESIGN ENGINEER</p> <p>D. SHU</p>	<p>DATE</p> <p>7/10/98</p>
<p>CHECKED BY</p> <p>J. CHANG</p>		<p>DATE</p> <p>7/7/98</p>	<p>OP. LEADER</p> <p>T.M. KUZAY</p>	<p>DATE</p> <p>7/15/98</p>
<p>DESIGNER</p> <p>CHANG/MUSCIA</p>		<p>DATE</p> <p>5/11/98</p>	<p>PROJECT MGR.</p> <p>J. CHANG</p>	<p>DATE</p> <p>7/7/98</p>
<p>APPROVED/RELEASED</p> <p>J. CHANG</p>		<p>DATE</p> <p>7/7/98</p>	<p>APPROVED/RELEASED</p> <p>DATE</p>	
<p>MATERIAL</p> <p>SEE NOT #4</p>		<p>SCALE</p> <p>HALF</p>	<p>SHEET</p> <p>11</p>	<p>DRAWING NUMBER</p> <p>S3-220002-01</p>

1	1.225 [31.12] WAS 1.254 [31.86]	M.J.M	J.C.	10/30/99
SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				
DO NOT SCALE DRAWING				